

Work Order ID 57160

March 24, 2010 8:44:05 AM



Page 1

Item ID: D206-642-341

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 24/03/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 07/04/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

PD

Date:

10-3-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2650

F

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

N/A *AD*

Document Control

Photocopy bluefile and create labels per PPP D206-642-341 CHG003

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
	Skidtubes								
Skidtubes	Memo	0.00							
	1-Deburr Fwd edge of tube								
	2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650								
	3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.								
	A/R <input type="checkbox"/> Aluminum Rod <u>M112507 / M113207</u> BE 10-3-30								
	4-Grind weld flush to cap on top surface only. BE 10-3-30								
	5-Cut aft end to length as per dwg D2650								
	6-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025. Open to Ø0.312"								
	7-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297".								
	8-Open Aft Cap Hole using #6 Drill Bit								
	9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650; D2650-5 Drilling Detail								
	10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650								
	11-Deburr and Blow out all chips from inside the tube								

DP 10-3-30

BE 10-3-30

BE 10-3-30

DP 10-3-30

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

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Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

130

Skid tubes

0.00



Skid tubes

Memo

0.00

Skid tubes

1-Open holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs cure time before cutting

Start Date: 10-3-31 Time: 9:15

Finish Date: 10-4-5 Time: 7:55 AM

A/R: SikaFlex-291 112429

SikaFlex expiry date: 10-8-20

AWM 10-3-31

AWM 10-3-31

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

140

QC5- Inspect part completeness to step on W/O

0.00

S 1204/05



QC

Memo

0.00

46

Quality Control

150

Skidtubes

0.00



Skidtubes

Memo

0.00

(1)

Skidtubes

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R ☐ Aluminum Rod ☒ M112507

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

4- Install nut plate as per dwg

BE 10/04/05

10-4-6

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



HandFinishing

0.00

HandFinish

Memo

0.00

Hand Finishing

Install D2680-041 Nut Plate as per Dwg D2650

N/A done on seq #150
DP10-4-6

170



QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

8/10/04/06

180



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

8/10/04/06

(70)

W/O:		WORK ORDER CHANGES						
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Cust Item ID:

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Customer:

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

BR 10-4-7 ①

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:30 AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 11:00 AM

=> 10/04/07

1 ①

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

① BR 10-4-20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Item ID:	D206-642-341	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Replacement Skidtube					
Start Date:	24/03/2010	Start Qty:	1.00			
Required Date:	07/04/2010	Req'd Qty:	1.00			
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	HandFinishing	0.00							
	HandFinish	0.00							
Hand Finishing	<div>Memo</div> <div>1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/R <input type="checkbox"/> Sikaflex-291 <input checked="" type="checkbox"/> Sikaflex expiry date: <u>10/08</u></div> <div>2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive</div> <div>3-Install MS27039-4-06 Screw as per DEO 9153</div> <div>4-Inspect for foreign object per QSI 024</div> <div>5-Install D2646 Aft Cap and seal with Sikaflex Clean excess adhesive A/R <input type="checkbox"/> Sikaflex-291 <input checked="" type="checkbox"/> Sikaflex expiry date: <u>10/08</u></div> <div>6-Wing Walk as per Dwg D2650-5 and QSI 005 4.4 Batch: <u>113545</u></div>								

10-4-21

①

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

8/6/21

Quality Control

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/6/21

Quality Control

250

Packaging

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP D206-642-341

Location: _____

PPP Rev: _____

PM 57154

[Signature]

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	QC21 - Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/04/27 *[Signature]*
MF
10-4-27

W/O:		WORK ORDER CHANGES								
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Picklist Print

March 24, 2010 8:44:09 AM

Page 1

Work Order ID: 57160

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube


Comments: IPP Rev: H05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC

Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960JD416		Purchased	No				Each	8.0000	1.0000			
												
Washer												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST357

111279

8

8

Each

513.0000

2.0000

CCR264SS3-3

Purchased

No



Cherry Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST311

111548

111827

112314

113539

113973

513

16

1

2

6

488

Each

236.0000

2.0000

CR3212-4-03

Purchased

No



Cherry Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST311

111359

112314

236

84

152

NAS1149D0463J

113706

BR 10-11-21

DA 10-4-6

2

DA 10-4-6

2

W/O:		WORK ORDER CHANGES						
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Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2620		Manufactured	No				Each	8.0000	1.0000			
												

Skidtube, 206 Skidtube

D2647



Cap

Manufactured No

Warehouse

Location

Main Warehouse

LG

55559

Loc Qty

Loc Code

8

8

Each

87.0000

1.0000



10-3-30

D2649



Cross Bolt Spacer

Manufactured No

Warehouse

Location

Main Warehouse

FP

55352

Loc Qty

Loc Code

87

87

Each

207.0000

19.0000



1 BE 10-3-30

Warehouse

Location

Main Warehouse

LG

36013

47112

48271

51529

55000

207

5

18

4

3

177

19 BE 10/04/05

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Shop Packet Print

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Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2654-5		Manufactured	No				Each	2.0000	1.0000			
												

Web

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

46638

2

2

Each

51.0000

1.0000

D2680-041



Nut Plate

Manufactured

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST021

33061

55366

51

1

50

Each

438.0000

54.0000

ALS4-1032-130



Insert

Purchased

No

220

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST282

110511

438

438

11/4/07

54 BL 10-4-21

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Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
AN960C10L		Purchased	No			220	Each	0.0000	54.0000			
												
washer												
AN960JD10L		Purchased	No			220	Each	3,003.000	2.0000			
												
Washer												

NAS 1149C0332R, 114344

54. Bl 10-4-21.

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST348

3003

101291

16

105793

49

110985 ✓

2938

2 Bl 10-4-21

D2646



Aft Cap

Manufactured No

220

Each

41.0000

1.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP6

36

46327

4

48109 ✓

4

52663 ✓

28

1 Bl 10-4-21.

Main Warehouse

fp7

5

52663

5

March 24, 2010 8:44:09 AM

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Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 24/03/2010

Required Date: 07/04/2010

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D2651-1		Manufactured	No			220	Each	348.0000	14.0000			
Plug												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

141

51530 ✓

141

Main Warehouse

fpa

207

53349

207

D2651-3

Manufactured No

220 Each

537.0000 14.0000



O-Ring

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

537

43849

3

46114 ✓

534

14 BR 10-4-21

14 BR 10-4-21

March 24, 2010 8:44:09 AM

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Page 5

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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March 24, 2010 8:44:09 AM

Page 7

Work Order ID: 57160

Parent Item: D206-642-341

Parent Item Name: Replacement Skidtube



Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC

Start Date: 24/03/2010

Required Date: 07/04/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3536-11		Manufactured	No			220	Each	14.0000	1.0000			
												
Gasket												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST497A

14

46649 ✓

10

46715

4

D3536-23

Manufactured

No

220

Each

8.0000

1.0000

Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

8

30754 ✓

1

53468 ✓

7

D3536-35

Manufactured

No

220

Each

11.0000

1.0000

Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

11

51628 ✓

11

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Page 7

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 57160



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 24/03/2010

Required Date: 07/04/2010

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
D3537-1		Manufactured	No			220	Each	53.0000	6.0000			
Wearpad												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

57510

52

48288**

2

55465

50

Main Warehouse

FP17

1

51678

1

D3537-3

Manufactured No

220

Each

24.0000

1.0000



Wearpad



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

57512

24

33881

4

35697

20

1

10-4-21

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Page 8

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 9

Work Order ID: 57160



Parent Item: D206-642-341



Parent Item Name: Replacement Skidtube

Start Date: 24/03/2010

Required Date: 07/04/2010

Comments: IPP Rev: H 05.10.11 Added D3429-1 per CHG004 KJ/CP/JLM
IPP Rev: I 08-09-29 revF as per dwg DD verified by: EC Est Rev: J 09-03-02 as per DSI9440 rev.a DD verified by: EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS27039-1-08		Purchased	No			220	Each	2,105.000	56.0000			
Screw												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST291

2105

110467

3

110552

102

110835

2000

MS27039-4-06

Purchased

No

220

Each

38.0000

1.0000



Screw

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST292

38

109061

38

56. BL 10-4-21

1 BL 10-4-21

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W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHIP COPY
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57160
B-10-3-24

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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57160
B-10-3-24

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	RMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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NOTE: Date & initial all entries

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

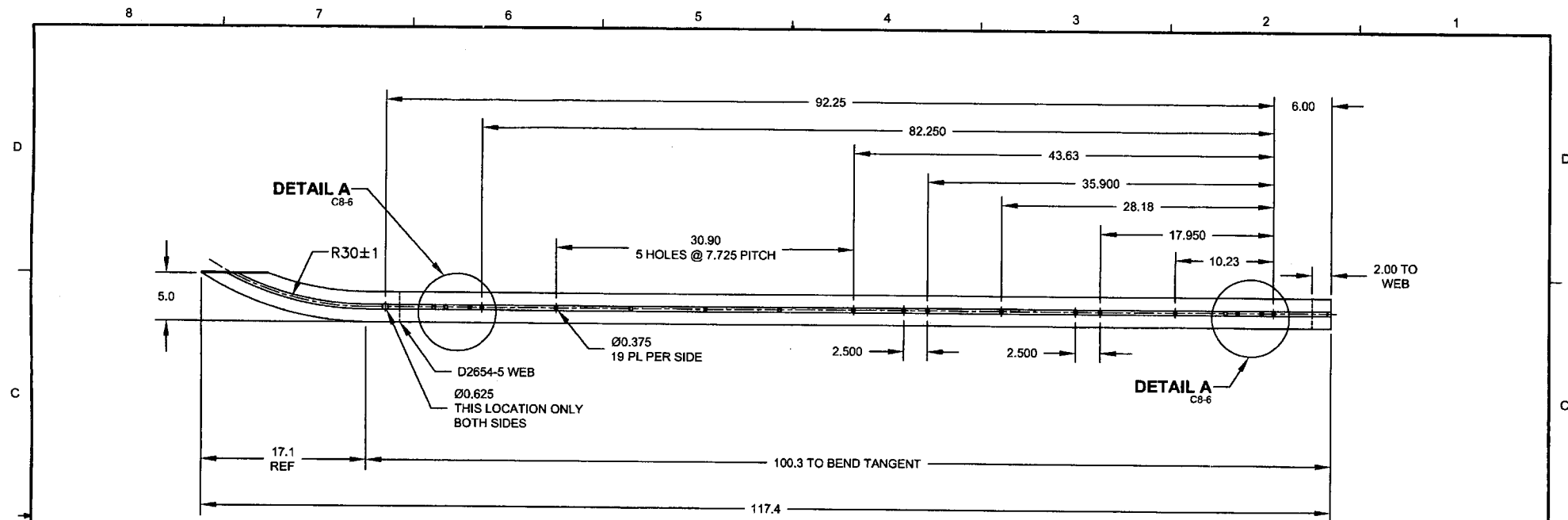
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DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

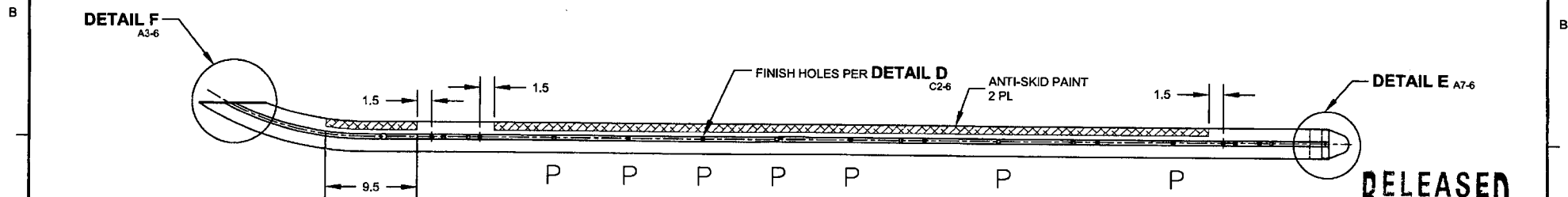
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D2650	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206/407 SKIDPOLE ASSEMBLIES	NTS
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W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

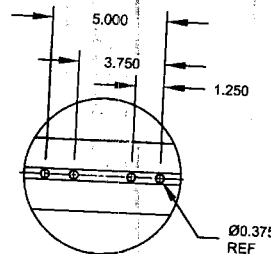
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Ch. Proo

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

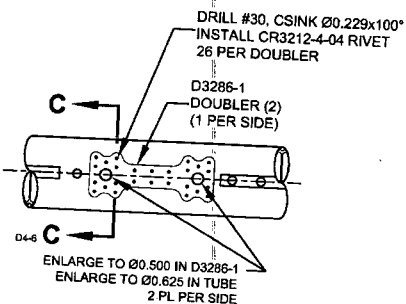
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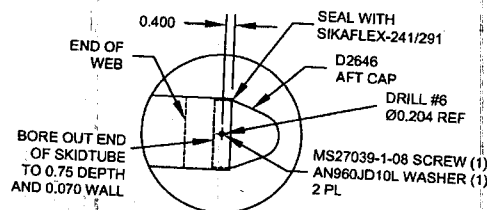
NOTE: Date & initial all entries



DETAIL A
SCALE 2X
C2-2
D7-2
C2-3
D7-3
C2-4
D7-4
C2-5
D6-5

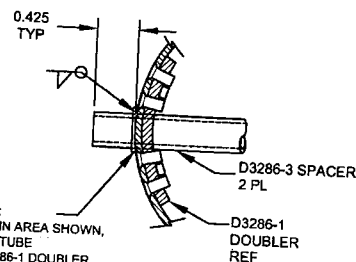


DETAIL B
SCALE 2X
C3-2
C3-3

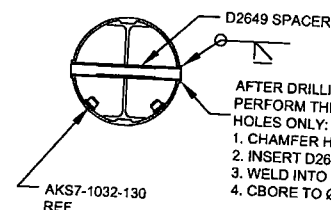


DETAIL C
SCALE 2X
B2-2
B2-3
B1-4
B1-5

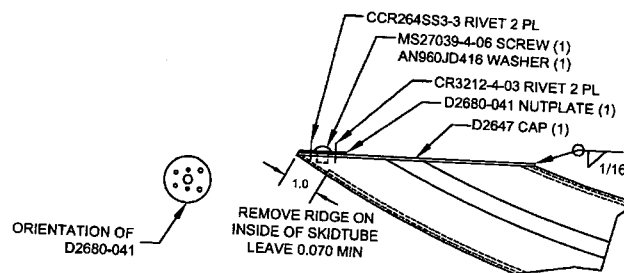
SECTION C-C
SCALE NONE
C7-6



- TO INSTALL D3286-1/3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030X45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE.



DETAIL D
FOR Ø0.375 HOLES ONLY
SCALE 3X
B4-2
B4-3
B4-4
B4-5






DETAIL E
SCALE NONE
B8-2
B8-3
B8-4
B8-5

DETAIL F NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
08-08-08

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
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DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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NOTE: Date & initial all entries

NO. 223

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 5577
Part number: 0206-642-441
Description: 206 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier Pat. Saff Date of Test Coupon 10.02.16
Welder Barclay Elliott Date of Test Coupon 10-02-16

The above named individual is qualified in accordance with AWS D17.1.2001 to weld